

THE FOLLOWING IS A REPOST OF ANOTHER DOCUMENT POSTED ON ARCHIVE.ORG CONTAINING BLUEPRINTS FOR A MARK II "STEN GUN". I HAVE BECOME ALARMED AT THE JOINT EFFORTS OF APPEASER GOVERNMENTS (SUCH AS THOSE IN SWEDEN) AND JIHADIST MIGRANTS TRYING TO SUBVERT CENTURIES-OLD ETHNO-NATIONAL AND CULTURAL ORDERS IN THE EUROPEAN WORLD. THUS, AM REPOSTING THIS FOR THE CONVENIENCE OF PARAMILITARY GROUPS WHOSE GOAL IS THE DEFENSE OF THE LOYAL CITIZENRY AND THE ANCIENT CULTURES THEY BELONG TO. BEING AS HOW THE STEN GUN IS ONE OF THE MOST ECONOMICAL OF ALL FULLY-AUTOMATIC FIREARMS, AND CAN BE EASILY MADE IN SMALL MACHINE SHOPS, IT IS THE BEST CANDIDATE FOR CITIZENS MILITIAS AND NATIONALIST PARAMILITARY GROUPS, SHOULD THE NEED TO DEFEND THEMSELVES AGAINST MALICIOUS COALITIONS OF APPEASER GOVERNMENTS AND JIHADIST GROUPS.

LEGALLY SPEAKING, I DO NOT OFFICIALLY ENDORSE THE CONSTRUCTION OF OR USE OF THIS WEAPON OR OTHERS LIKE IT. HOWEVER, THE READER MUST EXAMINE PAST EVENTS TO BECOME AS AWARE AS POSSIBLE THAT THE ACTIONS WHICH WERE THE MOST JUST WERE ALSO OFFICIALLY ILLEGAL.

IN SOME OF THESE CASES, REFUSAL TO TAKE LIBERTIES WITH LAWS HAVE GOTTEN THOUSANDS OF PEOPLE KILLED.

DON'T BE ONE OF THOSE STATISTICS.

SUMMANI

The

STEN

MKII

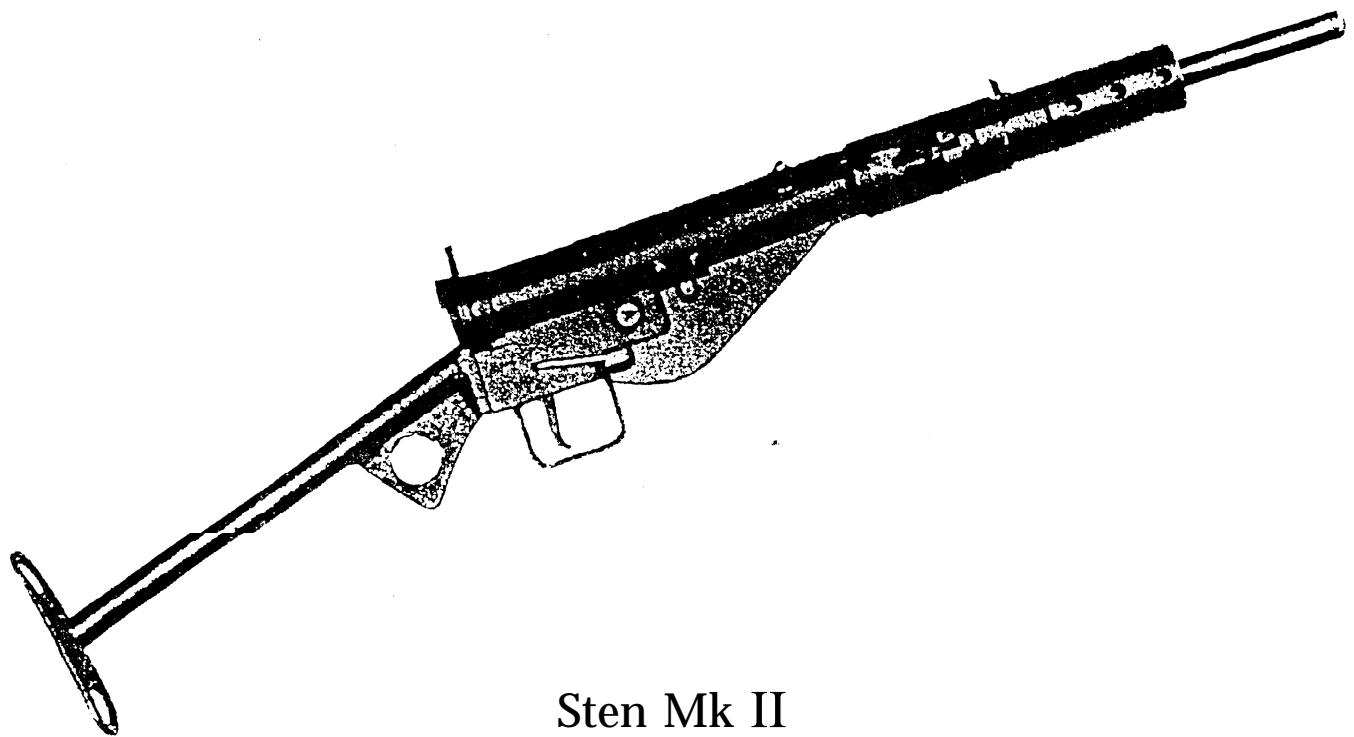
Complete machine plans



STEN SUBMACHINE GUN, 9-millimetre submachine gun that became the standard such weapon in the British Commonwealth armed forces during World War II. Moreover, hundreds of thousands of Sten guns were provided to underground movements everywhere in Europe during that war. The gun was so ubiquitous that its name became all but a generic term for submachine gun. The Sten gun remained in service until the late 1950s.

The most common version of the Sten gun was 30 inches (76.2 cm) long with a barrel of 7.5 inches (19 cm). It fired at a rate of 550 rounds per minute, and it had a 32-round box magazine that, however, tended to jam if more than 30 rounds were loaded. The butt was a steel frame that, with the barrel, could be removed without difficulty so that the disassembled weapon could be easily hidden. Its weight was just over six pounds (2.7 kg) unloaded.

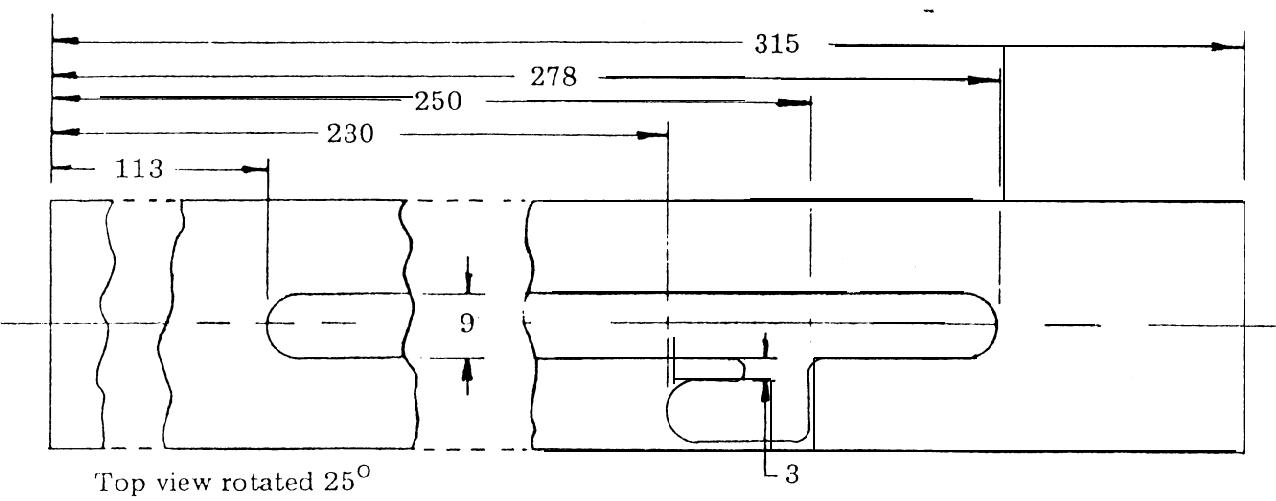
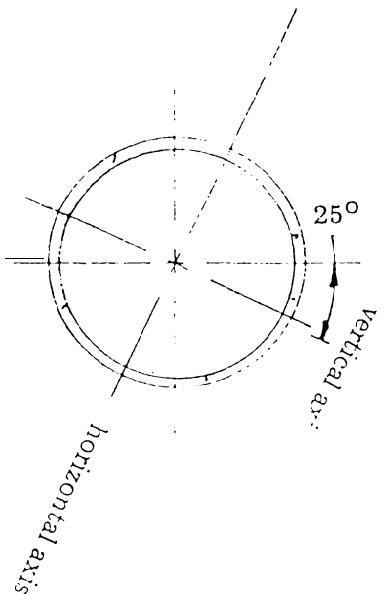
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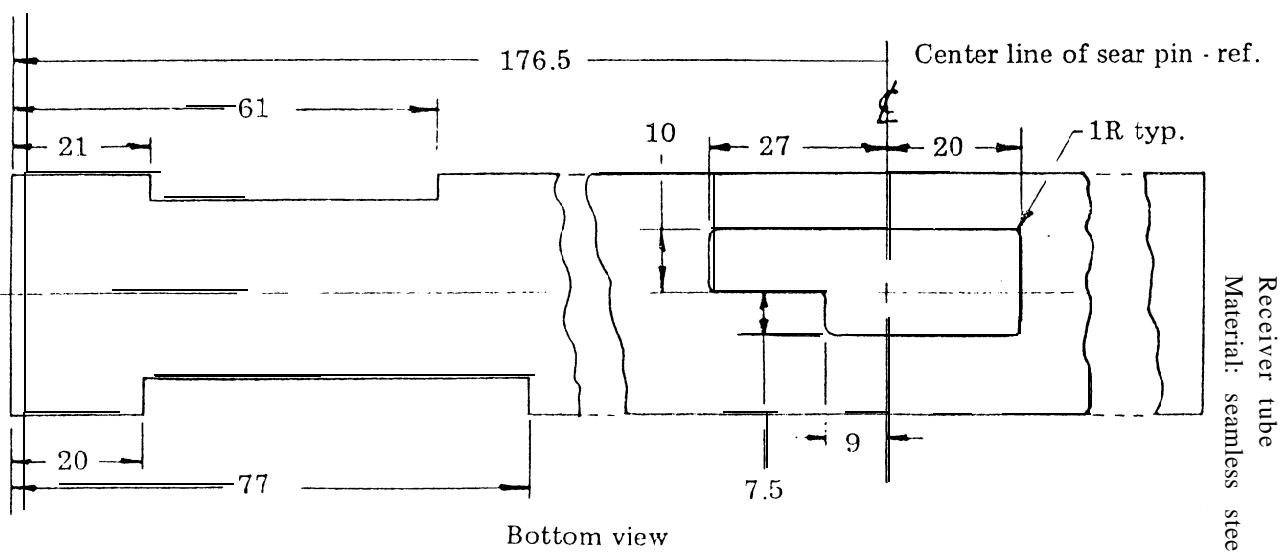
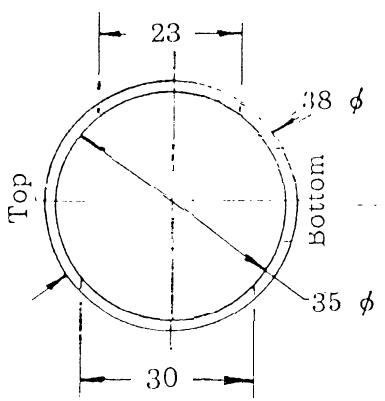
Sten Mk II

PARTS LIST

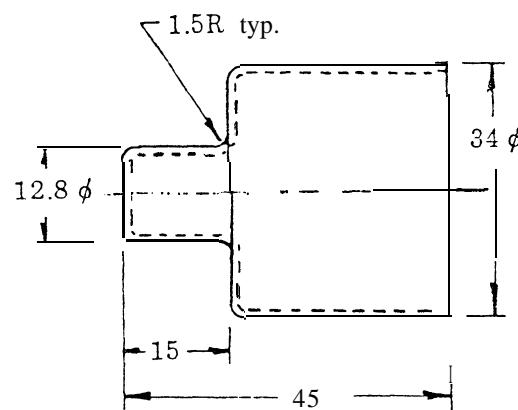
- | | |
|---|-------------------------------------|
| 1. Barrel | 24. Sear |
| 2. Barrel sleeve | 25. Sear spring |
| 3. Barrel sleeve lock | 26. Sear pin |
| 4. Barrel sleeve lock spring | |
| 5. Front sight | 27. Bolt |
| 6. Barrel bushing | 28. Firing pin |
| 7. Receiver tube | 29. Extractor |
| 8. Receiver cap | 30. Extractor spring |
| 9. Trigger housing | 31. Extractor pin |
| 10. Butt stock assembly: stock tubing
/ butt plate
stock grip
stock ring | 32. Bolt handle |
| 11. Magazine housing | 33. Closing spring |
| 12. Magazine housing spacer | 34. Closing spring cup |
| 13. Magazine housing spacer screw | 35. Trigger housing cover |
| 14. Magazine latch | 36. Trigger housing cover screw (2) |
| 15. Magazine latch spring | |
| 16. Trigger | 37. Magazine housing |
| 17. Trigger spring | 38. Magazine follower |
| 18. Trigger pin | 39. Magazine spring |
| 19. Disconnector | 40. Magazine spring latch |
| 20. Disconnector pin | 41. Magazine bottom |
| 21. Selector | 42. Rear sight |
| 22. Selector spring | |
| 23. Selector plunger (2) | |
- NOTES:
1. Bolt stopping surface on barrel is 1mm forward of magazine well slot.
 2. Bolt stroke is



Scale: .87 : 1

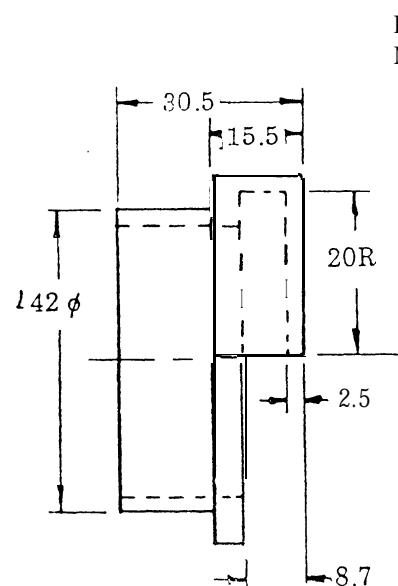


Receiver tube
Material: seamless steel tubing

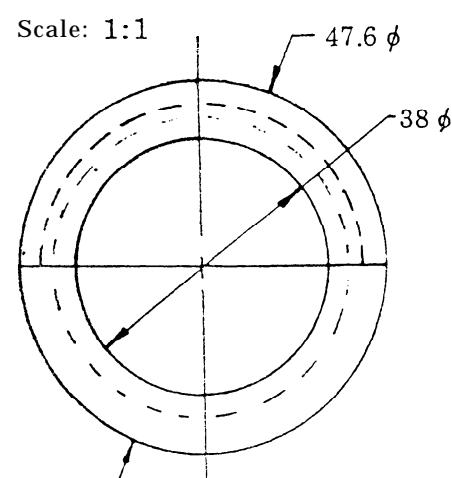


Main spring cap
Material: 1mm stock

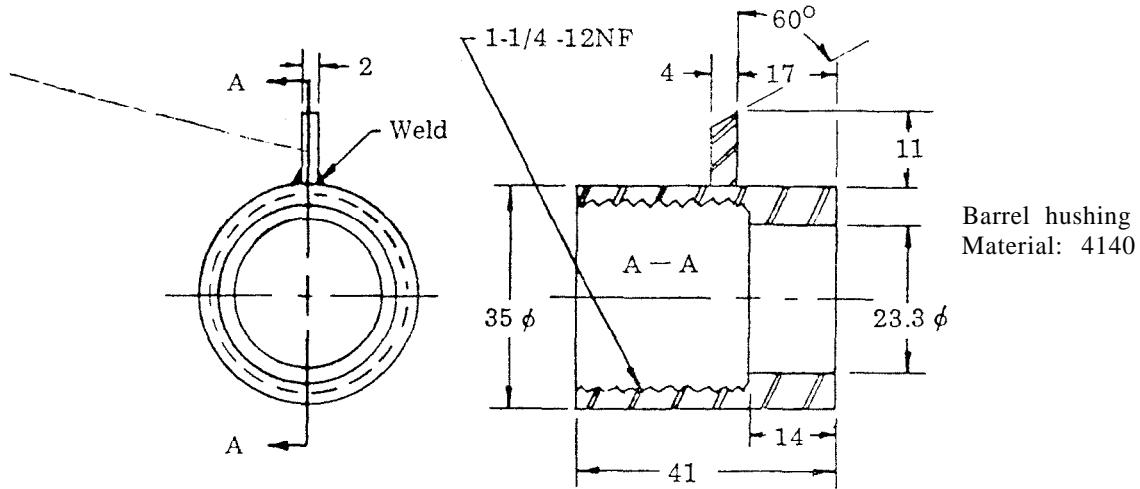
Scale: 1:1



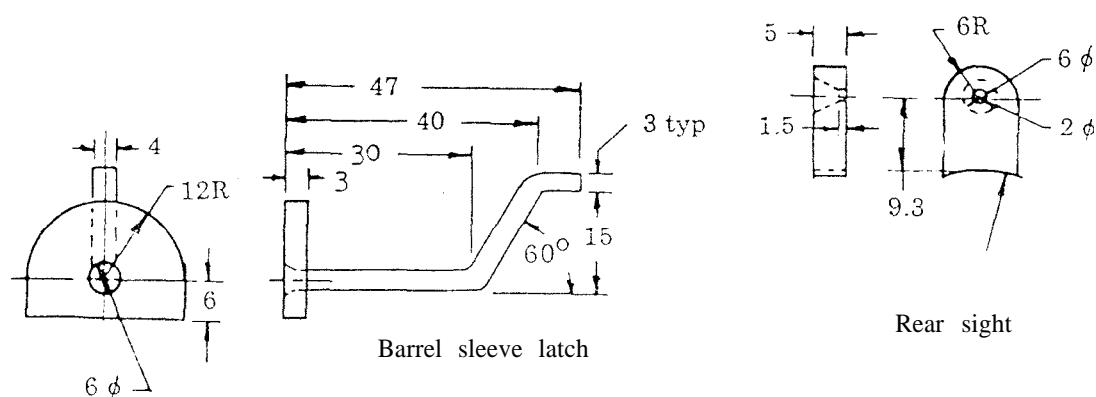
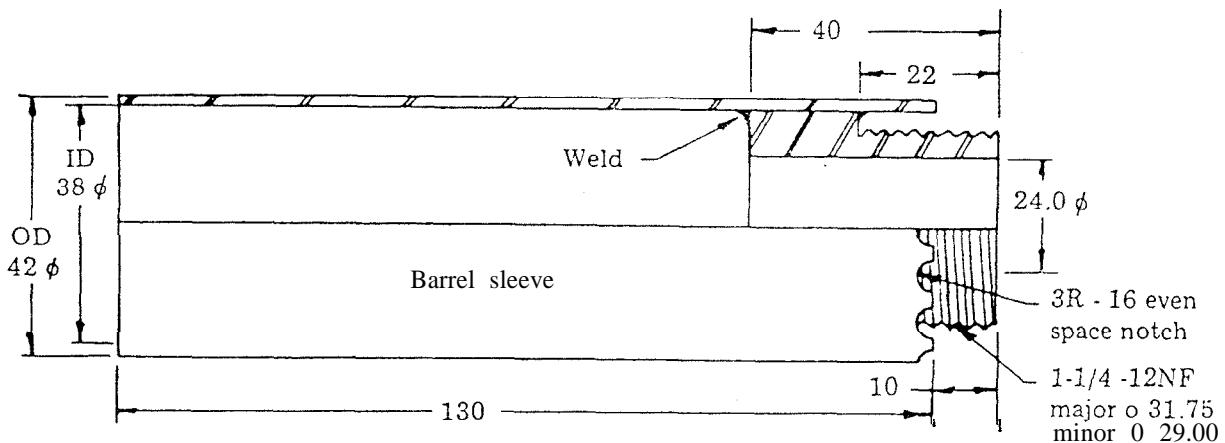
Receiver rear end bushing
Material: AISI 1010 or equivalent



Scale: 1:1

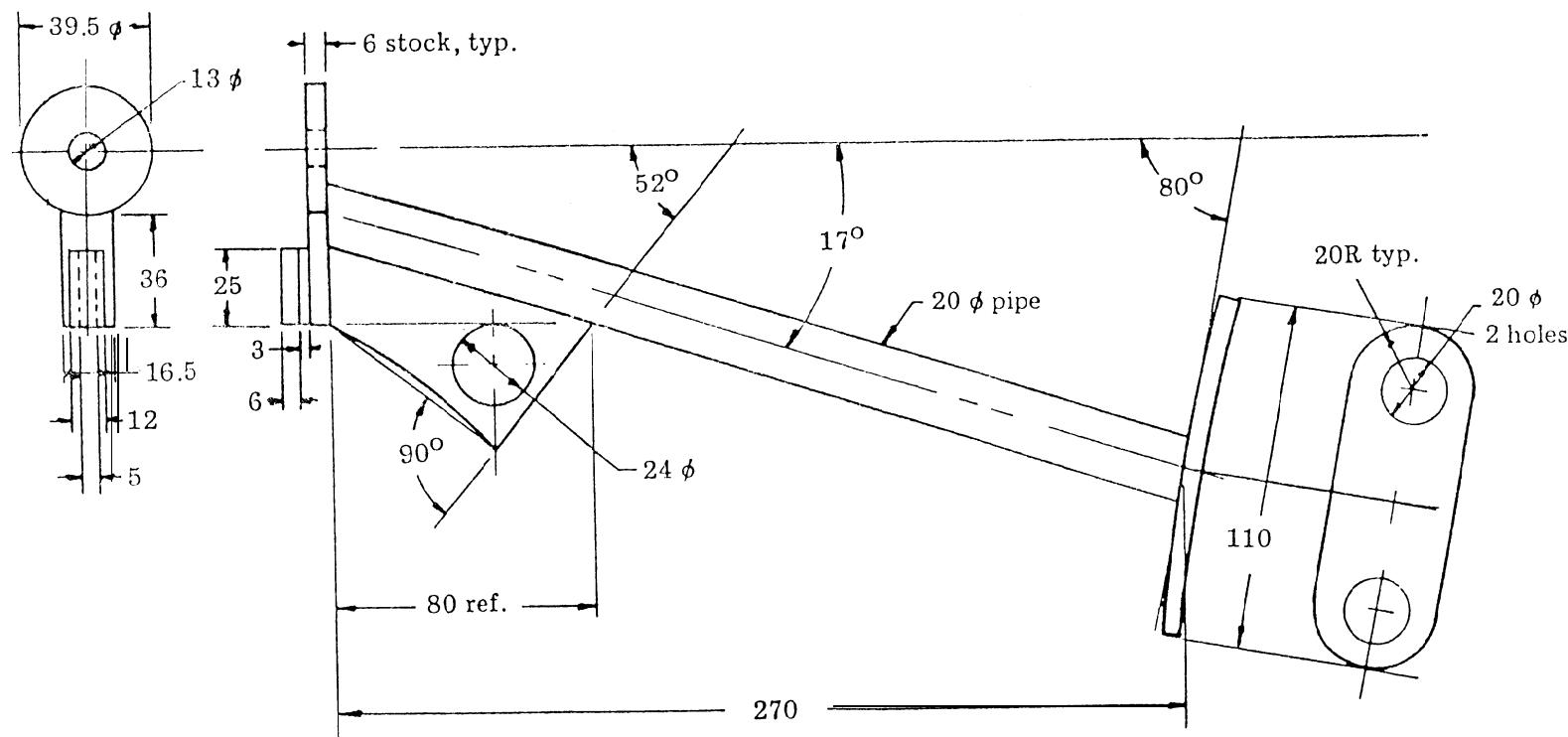


Scale:



Note: Stake at assembly
with magazine housing

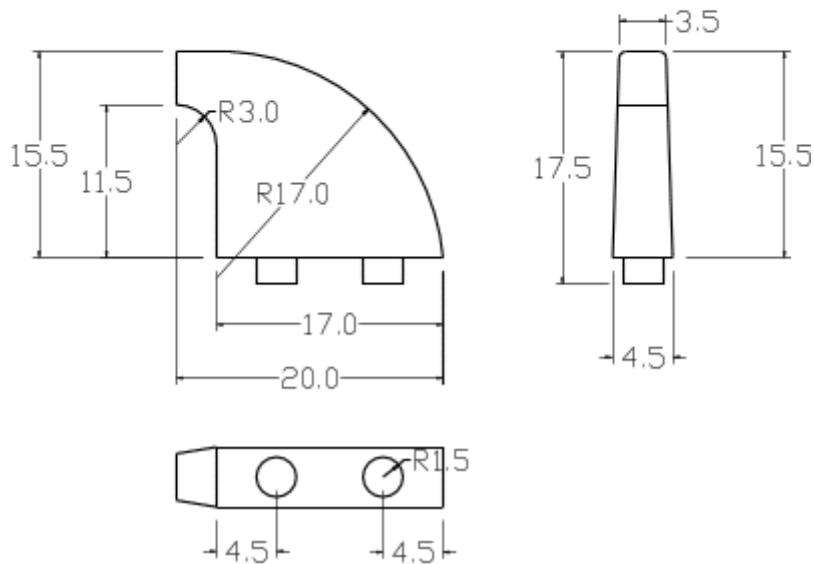
Butt-stock assembly
Material: low carbon steel
or aluminum, welded construction



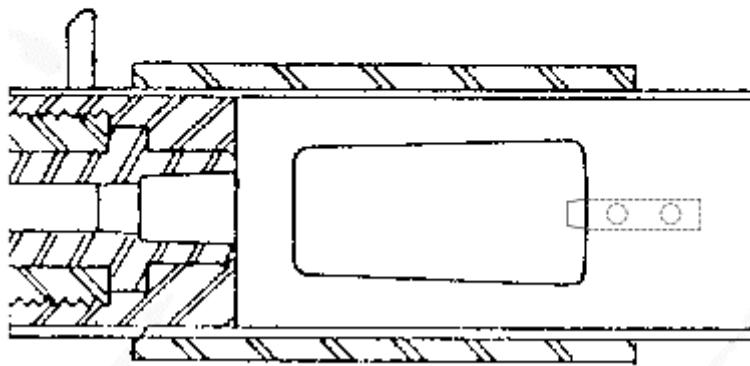
Ejector

Material: 4140 steel, hardened.

Construction: Mill, or filed from stock, pins shown can be replaced by slotting the receiver and welding in place, although harder to position

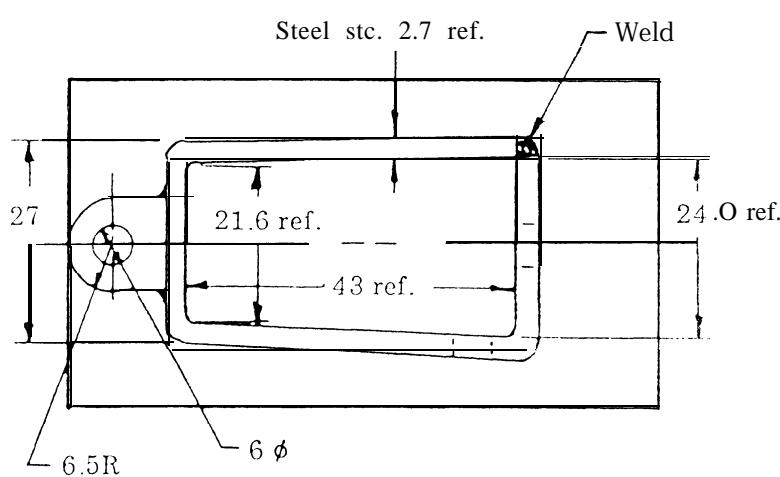
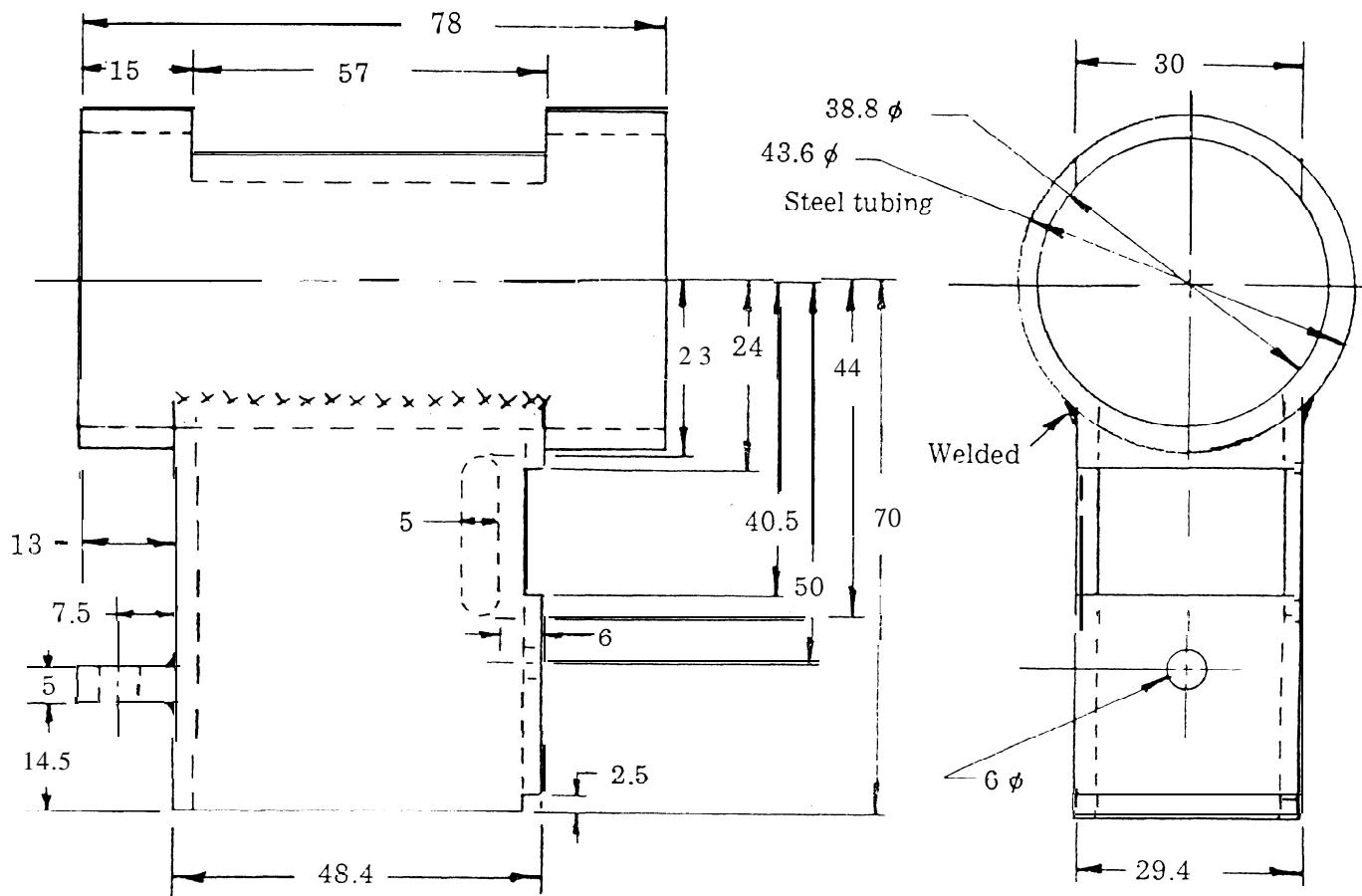


The ejector is positioned central with the magazine aperture of the receiver tube as shown. Construction can vary, here an ejector supported by two pins through the receiver tube is welded in place.



Magazine housing
Material: as noted

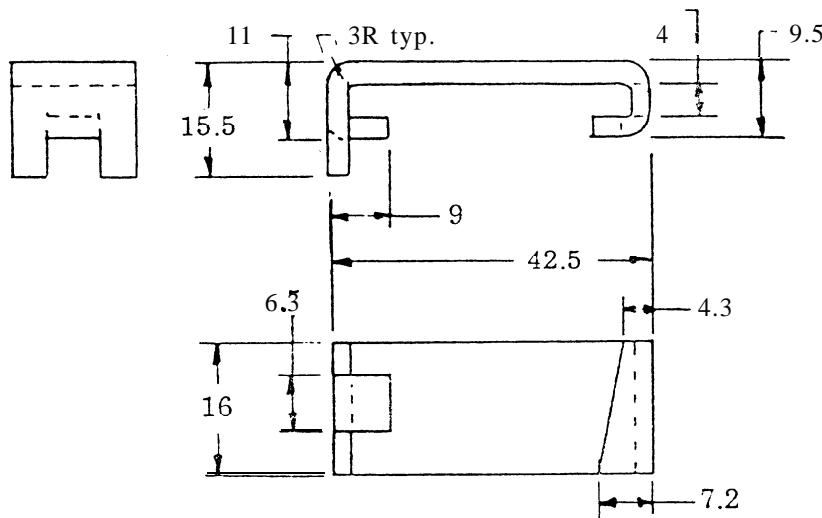
Scale: 1 : 1



Magazine latch

Material: AISI 1010 or equivalent
2.7mm stock. Case harden 0.1mm deep

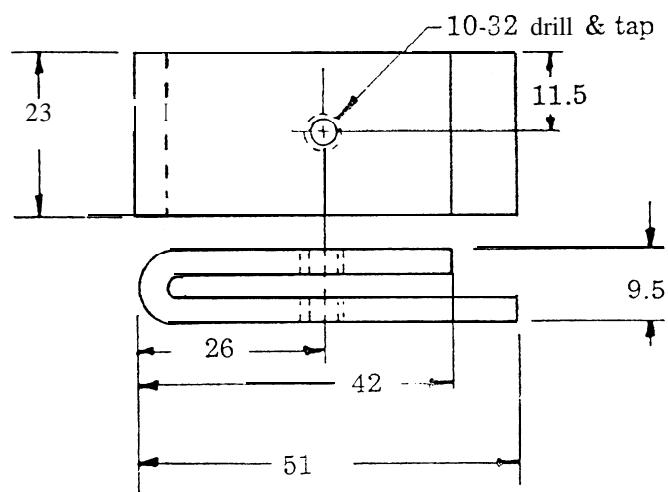
Scale: 1:1



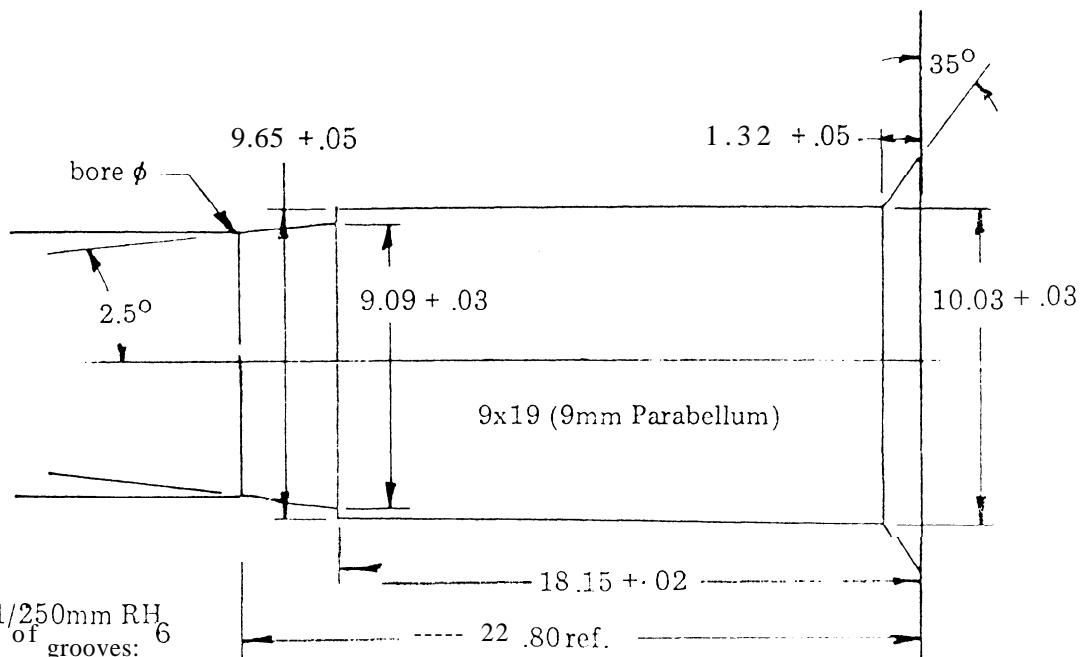
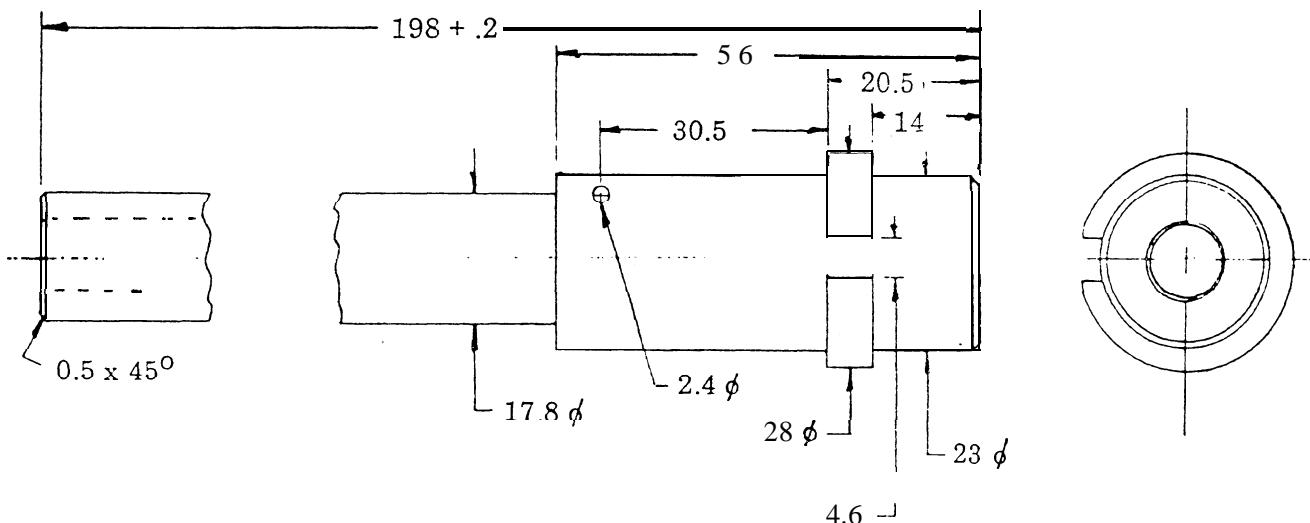
Magazine housing spacer

Material: AISI 1010 or equivalent
3mm stock. Heat treat: none

Scale: 1:1



Barrel
Material: AISI 4140
Harden to: Br 255-277



Twist: 1/250mm RH
Number of grooves: 6
Groove width: 2.5 + .02
Bore diameter: 8.84 + .02
Rifling diameter: 9.06 + .05

STEN Mk II SPECIFICATIONS

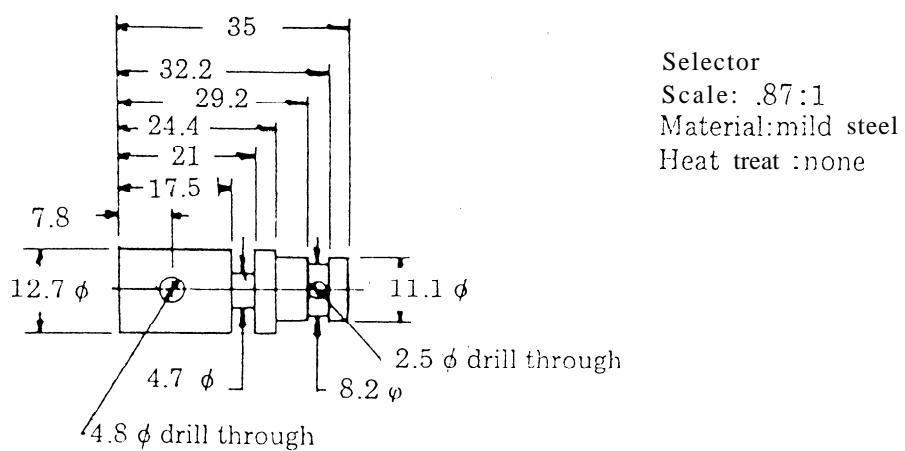
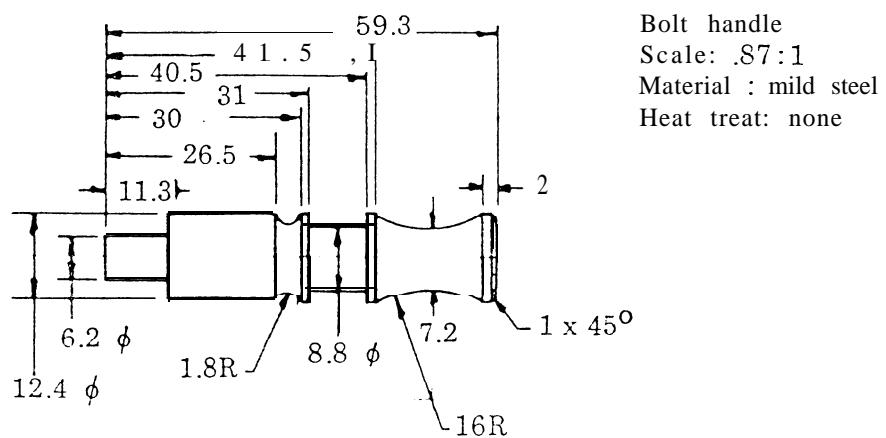
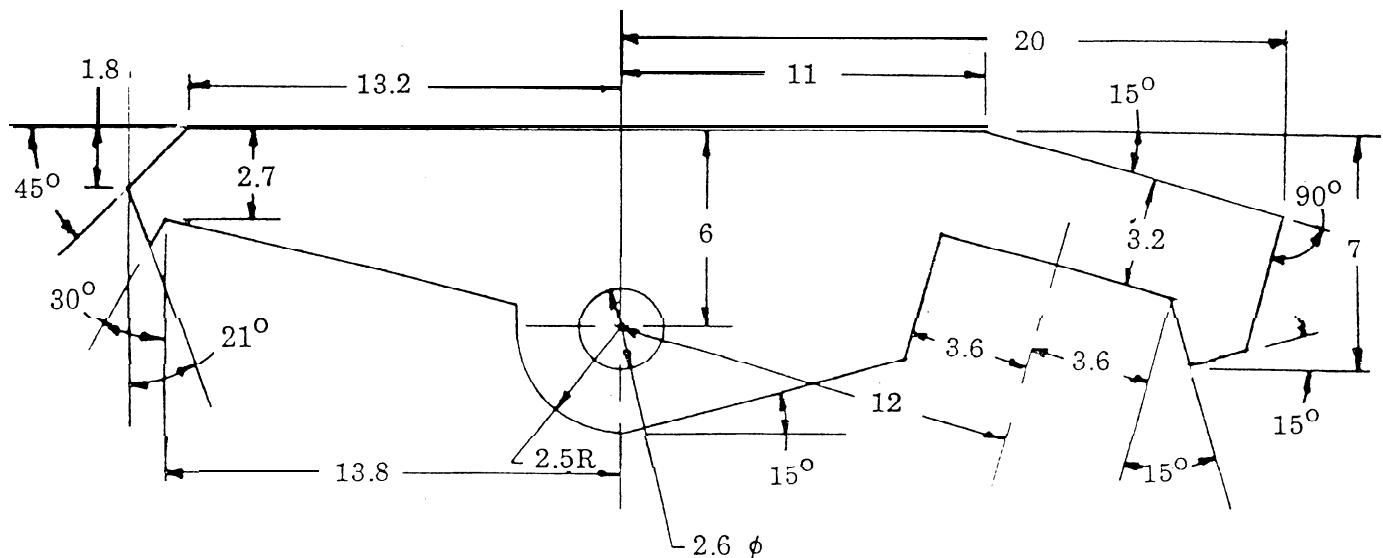
1. Cartridge:	9mm Parabellum	
	Bullet weight	116 grains
	Powder weight	6 grains
	Muzzle velocity	1400 ft./sec.
2. Recoil Spring:	Wire diameter	0.067 in,
	Spring OD	1.00 in.
	Active coils	15
	Free length	9.40 in.
	Initial length	6.80 in.
	Final length	3.20 in.
	Work stroke	3.60 in.
3. Bolt:	Weight (including extractor)	1.327 lb. (9290 grains)
	Cocking handle	0.077 lb. (540 grains)
	Total recoiling weight:	1.404 lb. (9830 grains)
	Bolt maximum dia.	1.381 in.
	Bolt overall dia.	5.75 in.
	Bolt body length	4.21 in.

SUGGESTED STEN MANUFACTURING MODIFICATIONS

1. Select suitable lightwall steel tubing which is commercially available. For example, a fence post pipe (galvanized) is 38.5mm OD and 35.0mm ID, most suitable for use as a receiver.
 2. Eliminate barrel sleeve.
 3. Weld barrel bushing into the front end of the receiver for simple, permanent assembly.
 4. Turn barrel blank OD (outside diameter) without any shoulder, fit the barrel in the bushing by sliding fit.
 5. Fasten the barrel in the bushing by two roll pins of 3/16" diameter, or equivalent.
 6. Turn the bolt OD to fit the receiver ID.
 7. The external portion of the cocking handle (sticking out of the receiver) may be a straight 8.8mm OD, the same as the inside.
 8. The trigger housing cover acts only as a guard against dirt entering the trigger assembly. This cover can be eliminated or made from plastic.
 9. All pins can be roll pins of standard commercial size, or pieces of drill rod.
 10. All springs can be of a standard commercial size.
 11. Trigger material may be aluminum or plastic, side tabs may be replaced by spacers or washers to keep the trigger located neutrally.
 12. 1-1/4" diameter nominal size galvanized pipe, schedule 40 is suitable for a modified receiver:
 OD: 42.2mm
 ID: 35.05mm
 Wall thickness: 3.55mm
- Note: A 1" galvanized pipe fits loosely inside a 1-1/4" pipe and can be welded as a filler-spacer where needed,

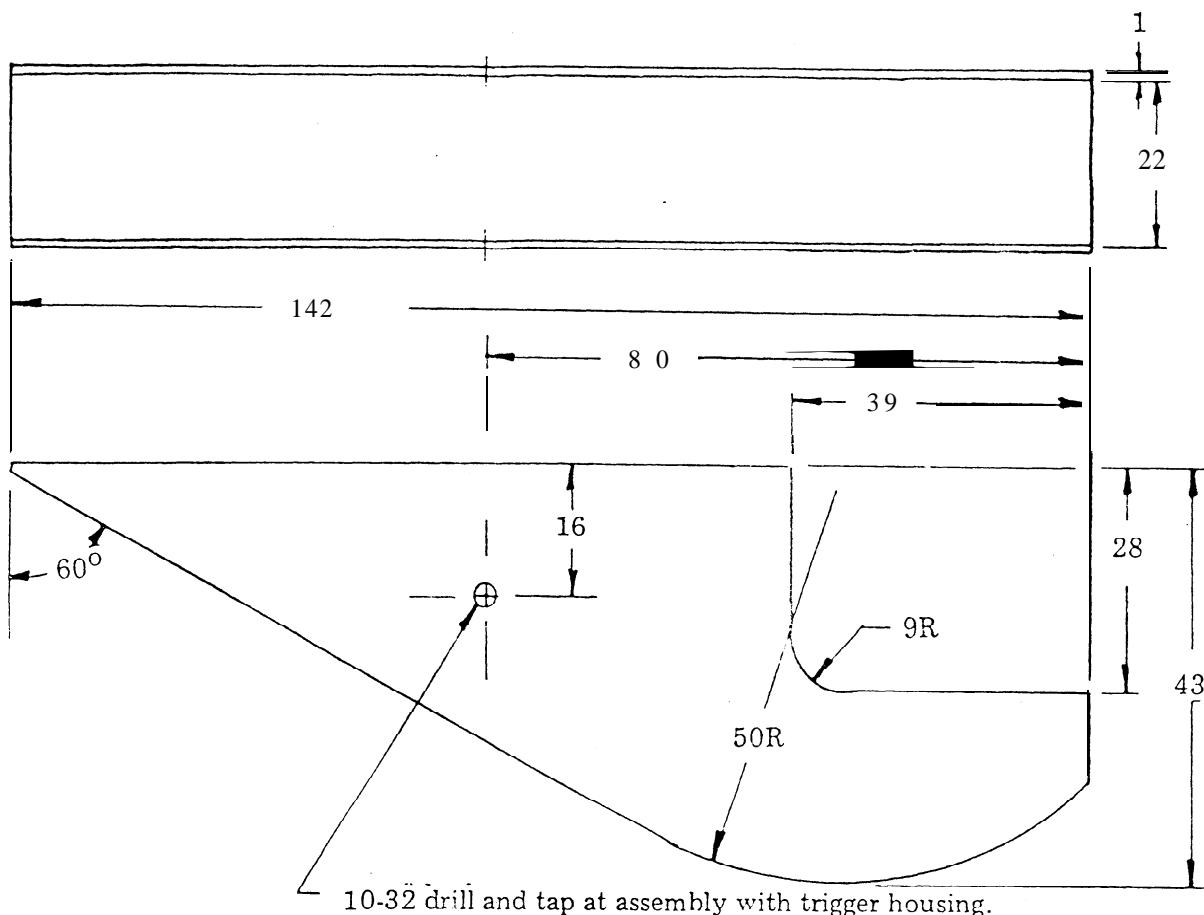
Extractor
Scale: 4.5 : 1

Material: AISI 1040 or equiv., stock 4.7 wide
harden to: Rc 48-52

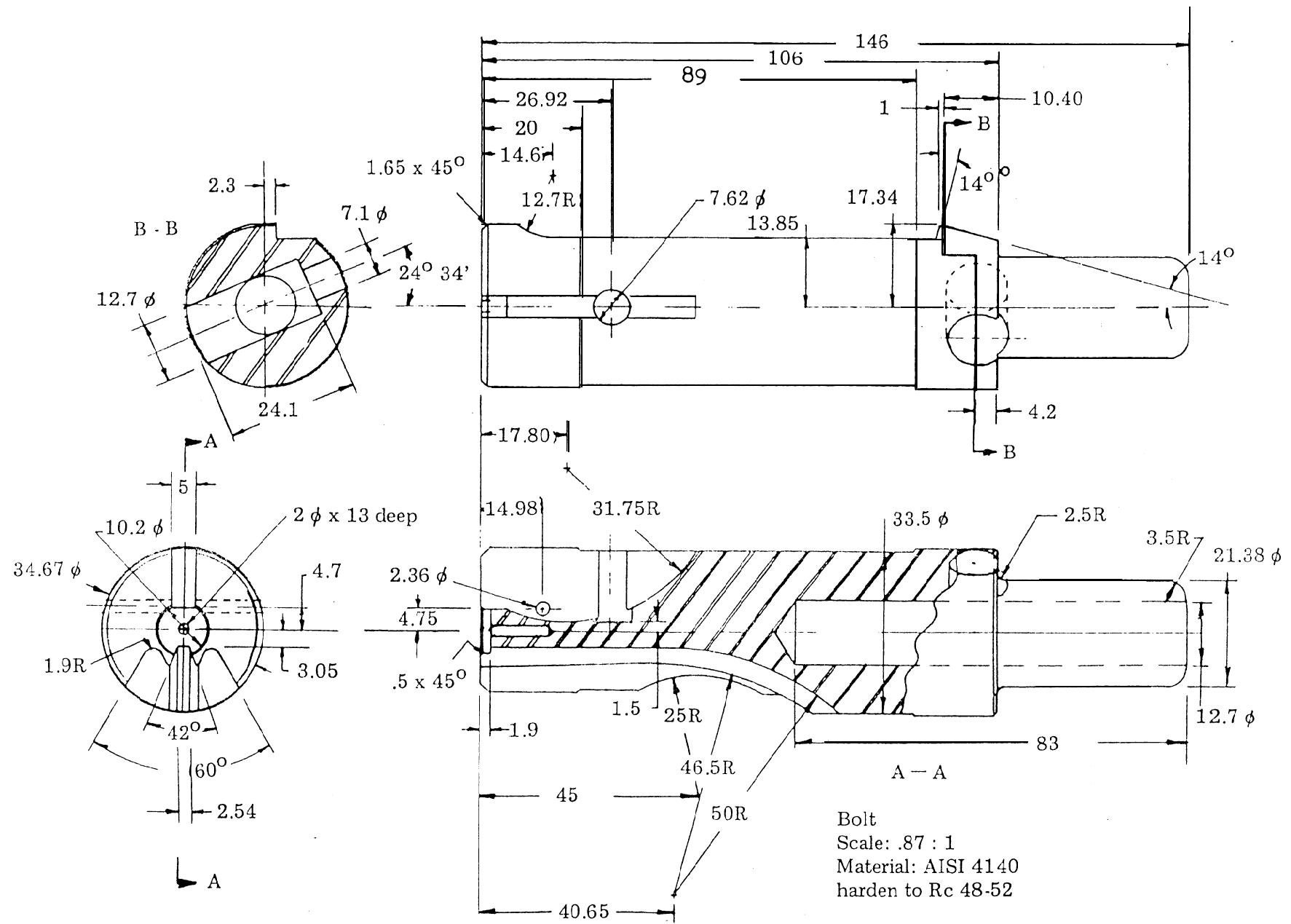


Trigger housing cover
Material: 1mm stock, formed
Required: 1

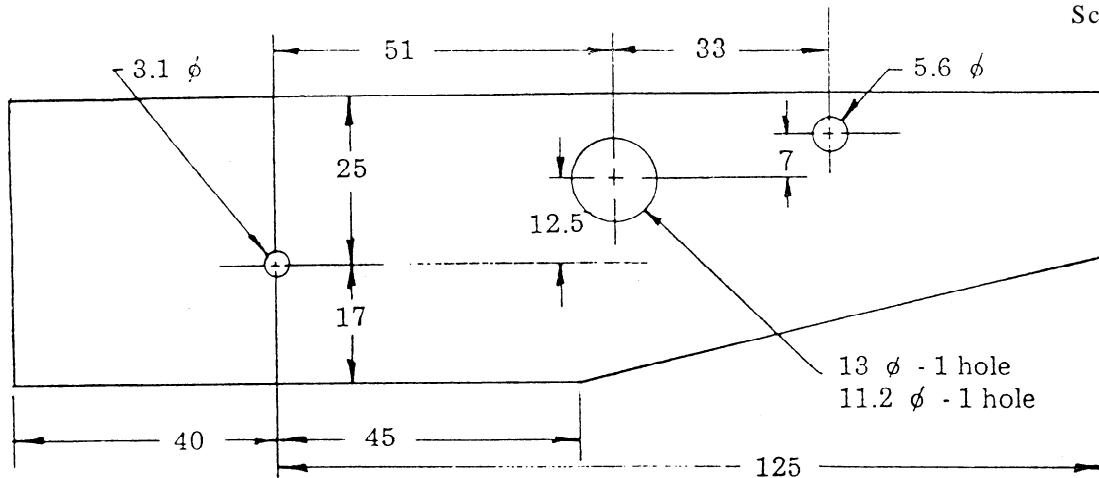
Scale: 1:1



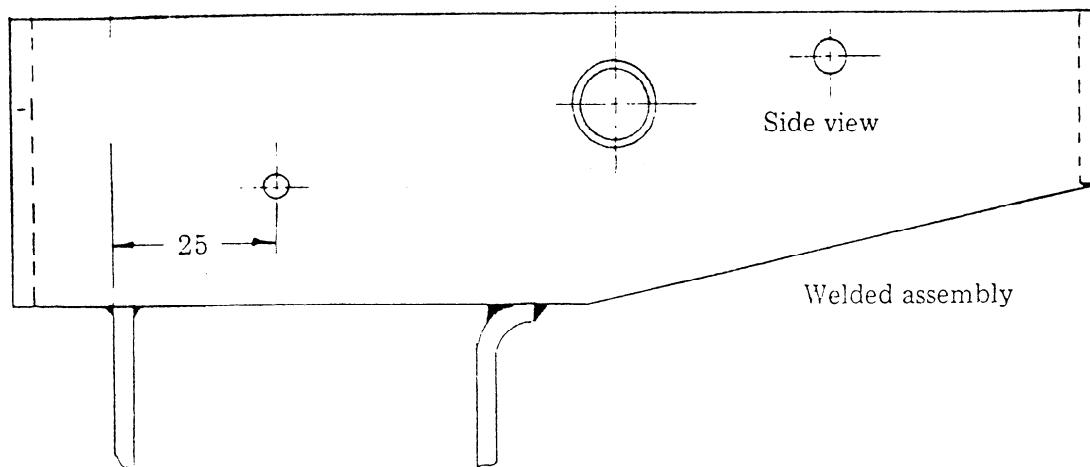
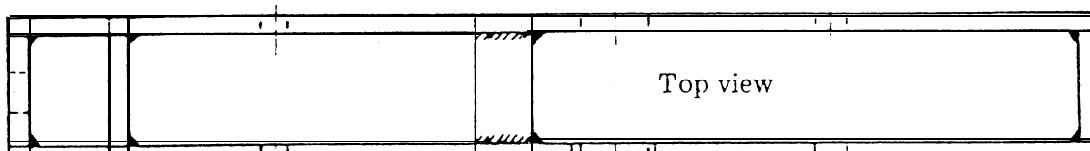
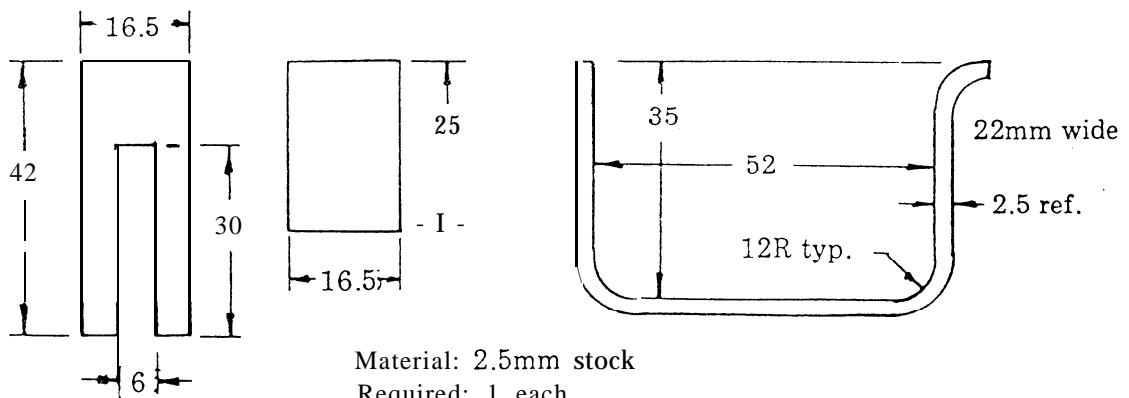
All Sten screws are 10-32 thread, round head type. Trigger housing screws (2) are 13mm long.

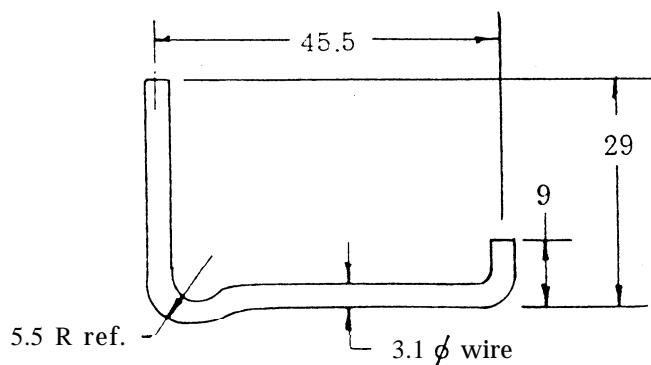


Trigger housing
Scale: .87:1



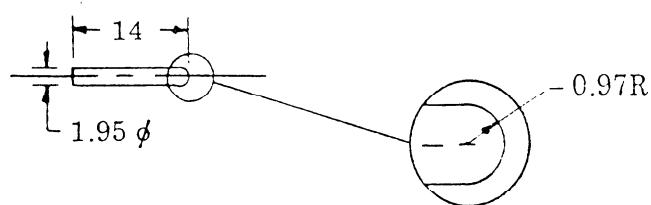
Material: 2.5mm stock
Rewired: 2





Trigger pin

Note: Trigger pin may be substituted by spring pin 3.1ϕ by 26 long.



Firing pin
Material: Drill rod
Harden to Rc 50

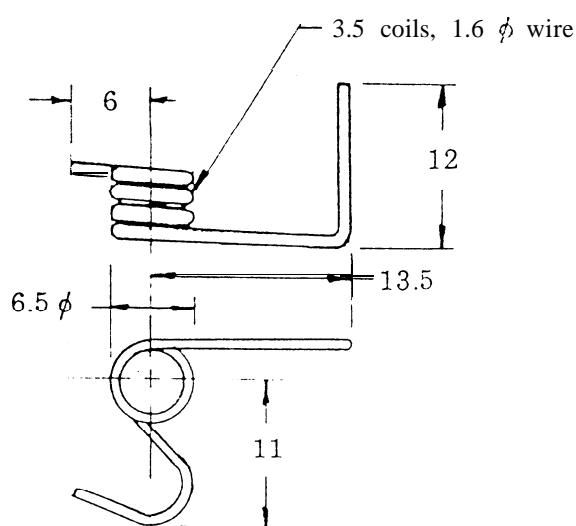
PINS (Spring pins)

USE	DIAMETER	LENGTH
Extractor	2.5	25
Sear	5.5	24

SPRINGS

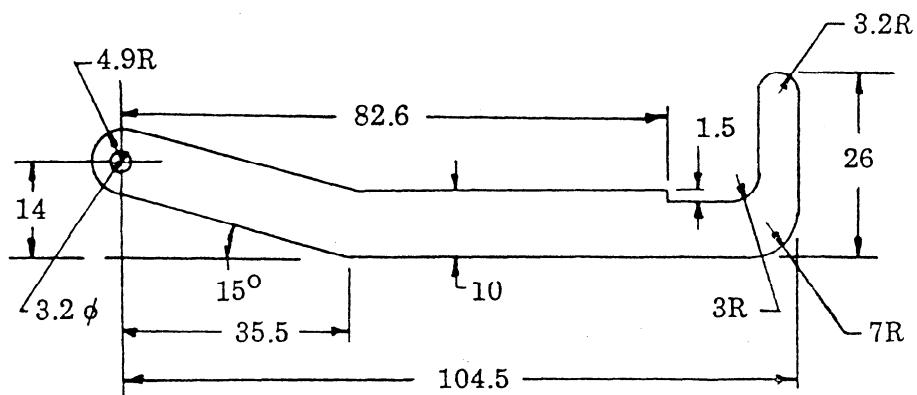
USE	Wire dia.	Coil OD	Free length	Number of coils	Coil ends	SUBSTITUTE":
Extractor	1	7.1	12	5.5	Sq.	LC-040C-4
Magazine latch	1	8.7	15.5	6	Gr.	LC-040C-6
Closing	1.6	26.5	245	17	Sq.	
Trigger	0.7	4.6	57	72	Extension spring or loops	LE-026B-7 or LE-026C-8
Selector	0.45	4.6	14	8	Gr.	LC-018B-6
Barrel sleeve latch	1	8.7	35	15	Sq.	

Sear spring, formed
substitute LT-059K-1-R



*Lee Spring Company, 30 Main St., Brooklyn, NY11201; catalog No.112/1970

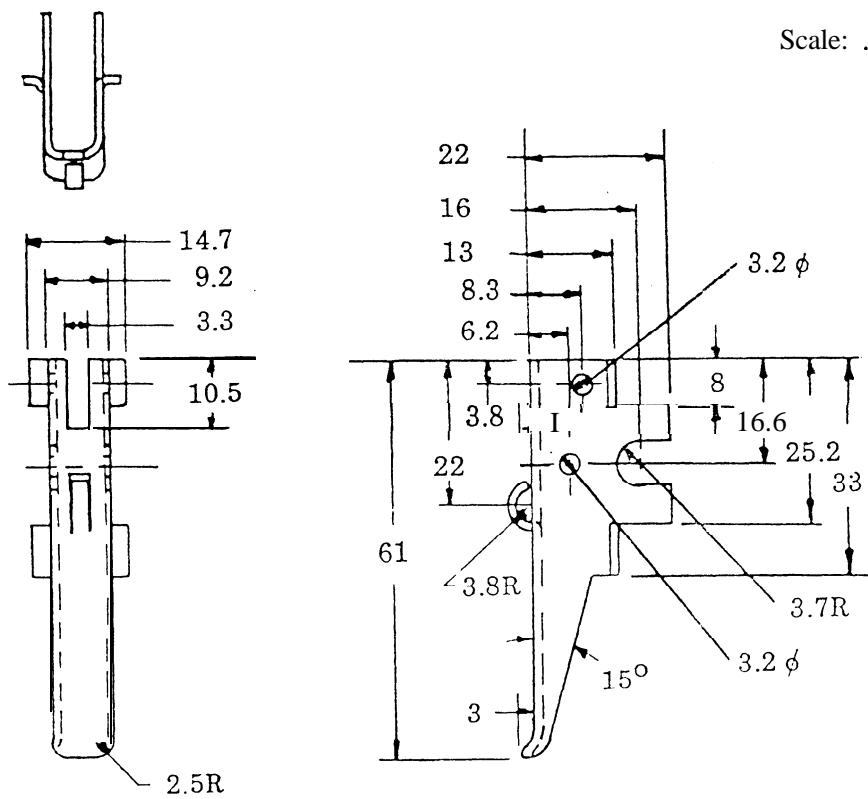
Scale: .87 : 1

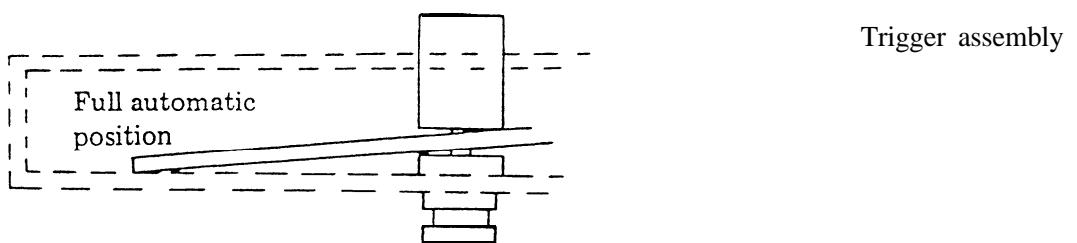


Trigger

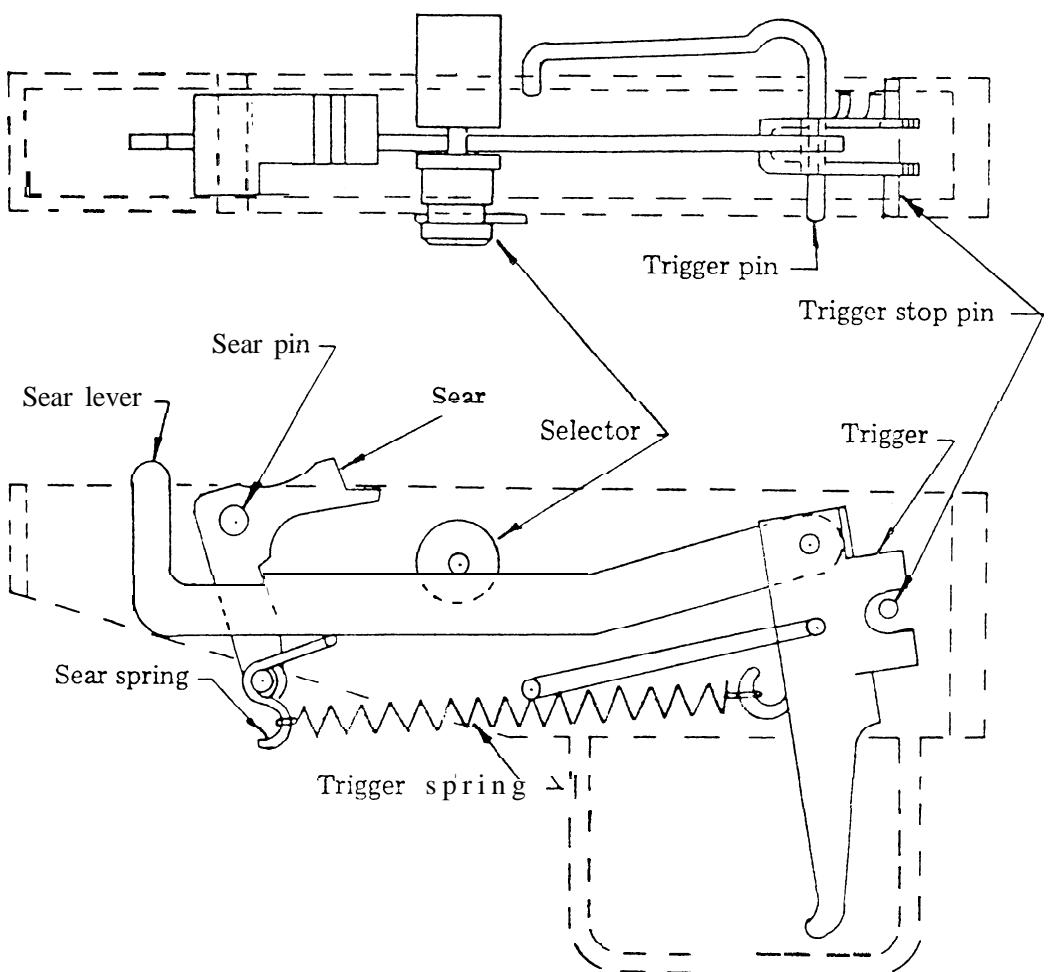
Material: AISI 1010 or equivalent,
1.6mm stock
Heat treat: none

Scale: .87 : 1

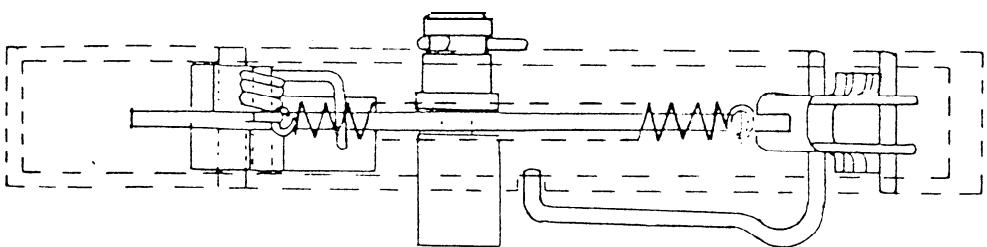




Top view



Bottom view

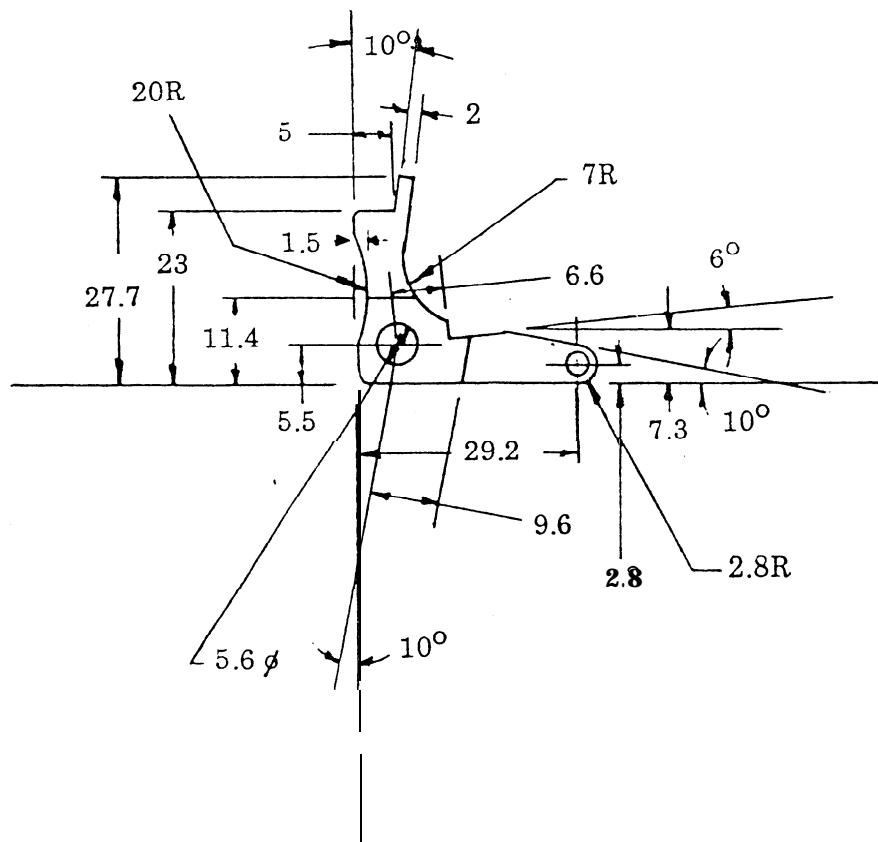
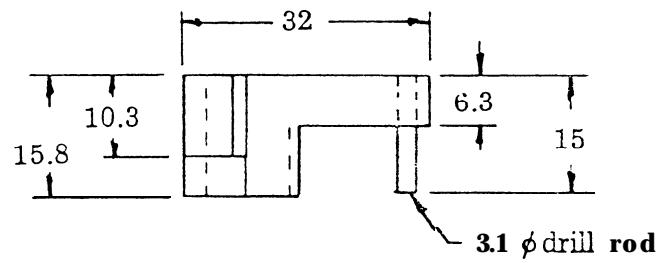


Sear

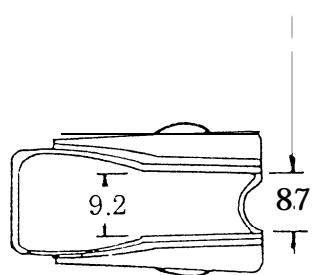
Material: AISI 4140 or equivalent

Harden to Rc 55

Scale: 1:1

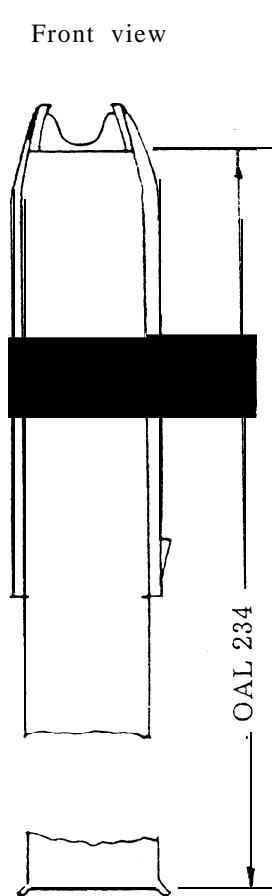


Top view

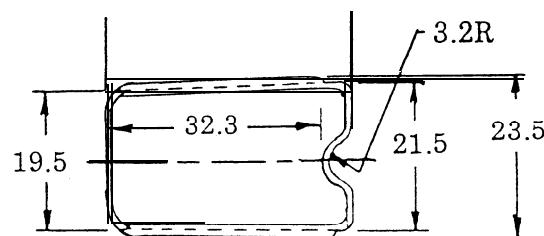
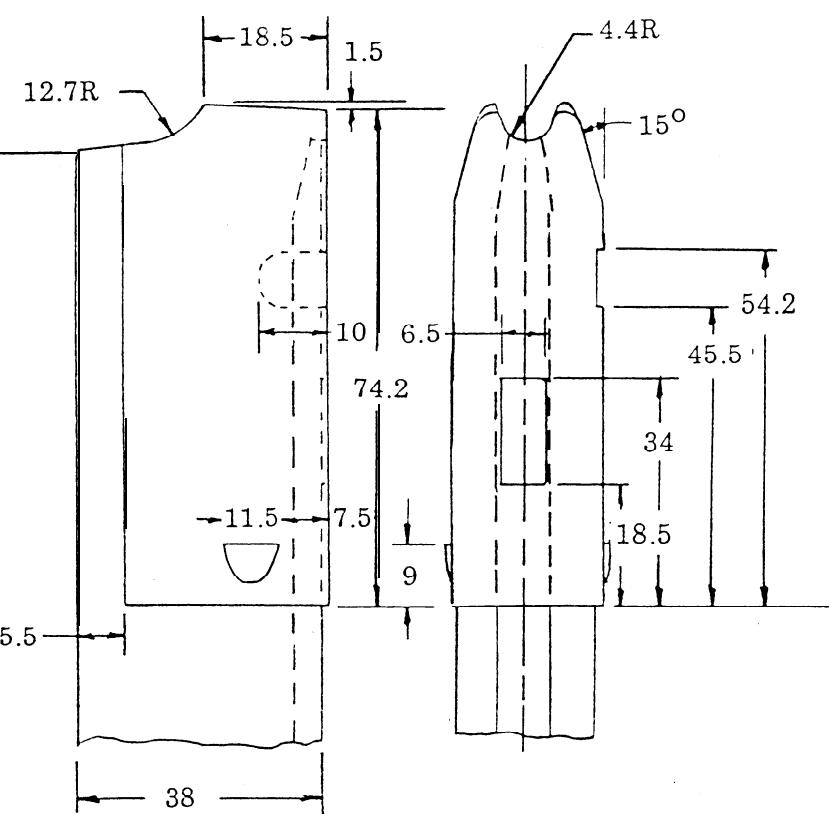


Magazine
Material: 1mm steel stock

Front view



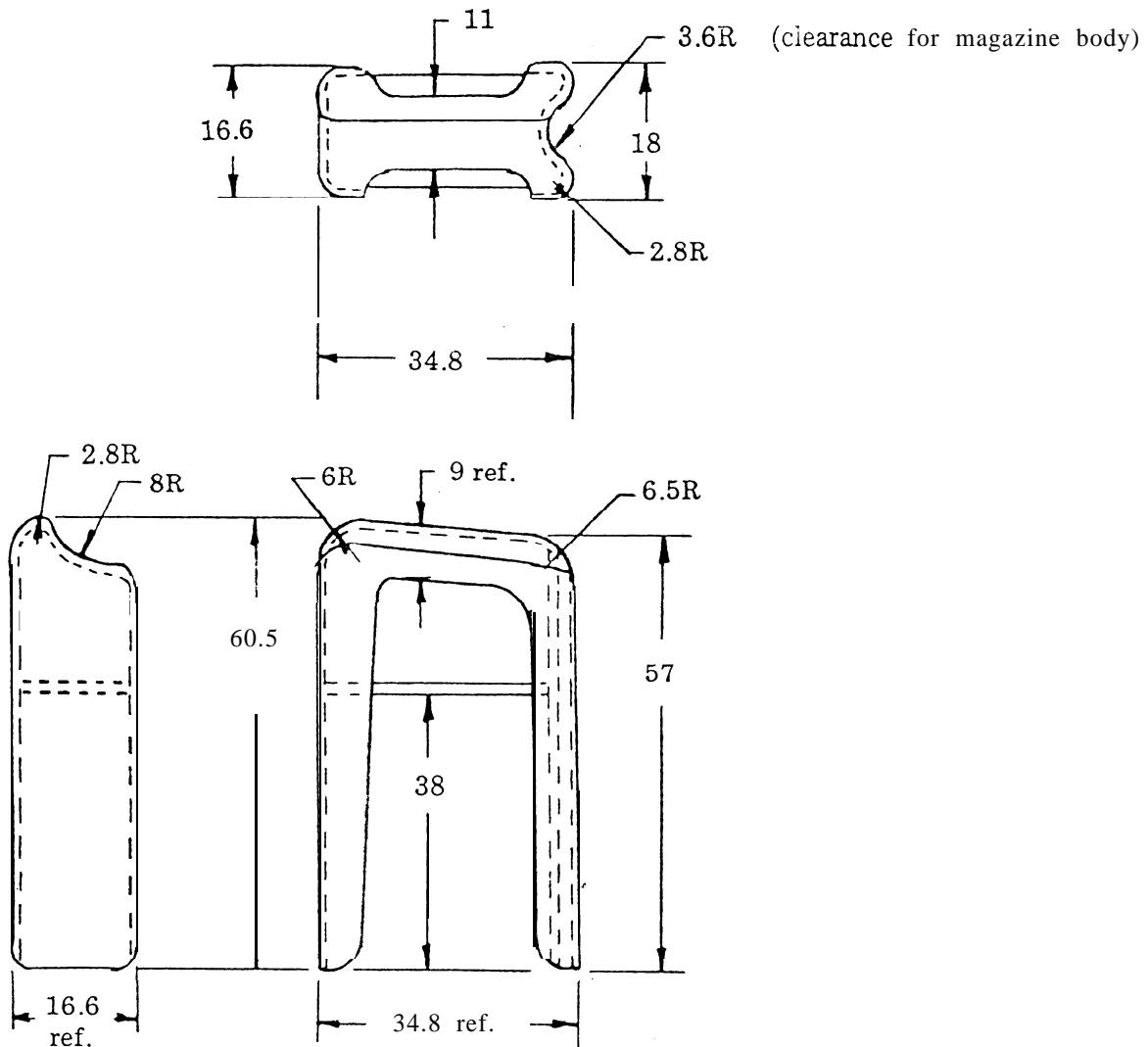
Rear view



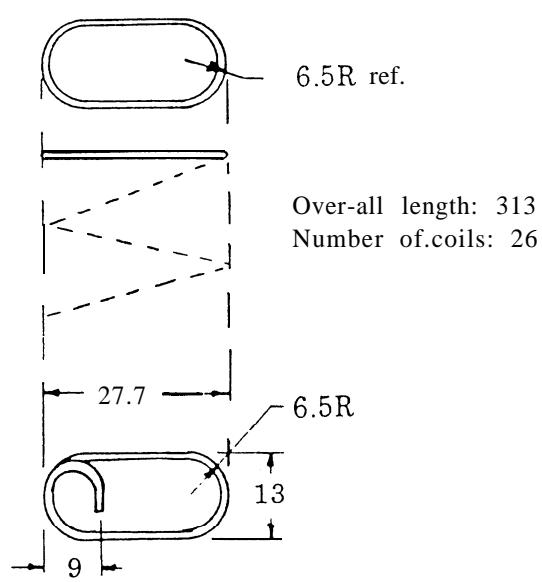
Bottom view

Magazine follower
Material: low carbon steel

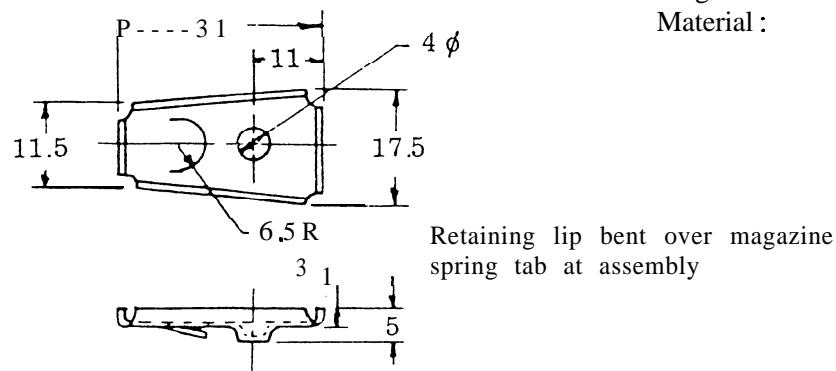
Scale: 1:1



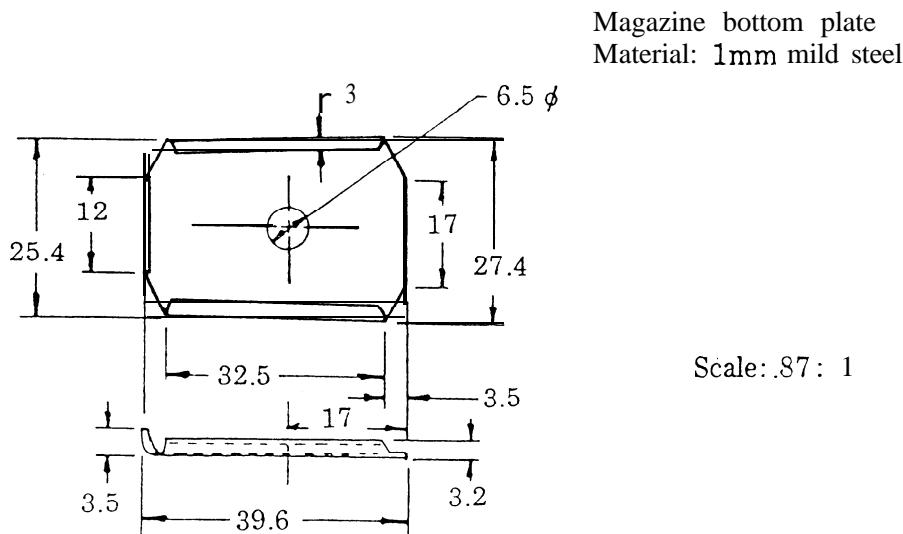
Note: The magazine follower is a complex stamping made on a progressive die. To make a follower in a simpler way is to follow the Degtyarev DP LMG approach — using a dummy round as the last one in the magazine. Thus a simple, flat follower with a dummy round soldered and/or screwed to it will replace a complicated stamping.



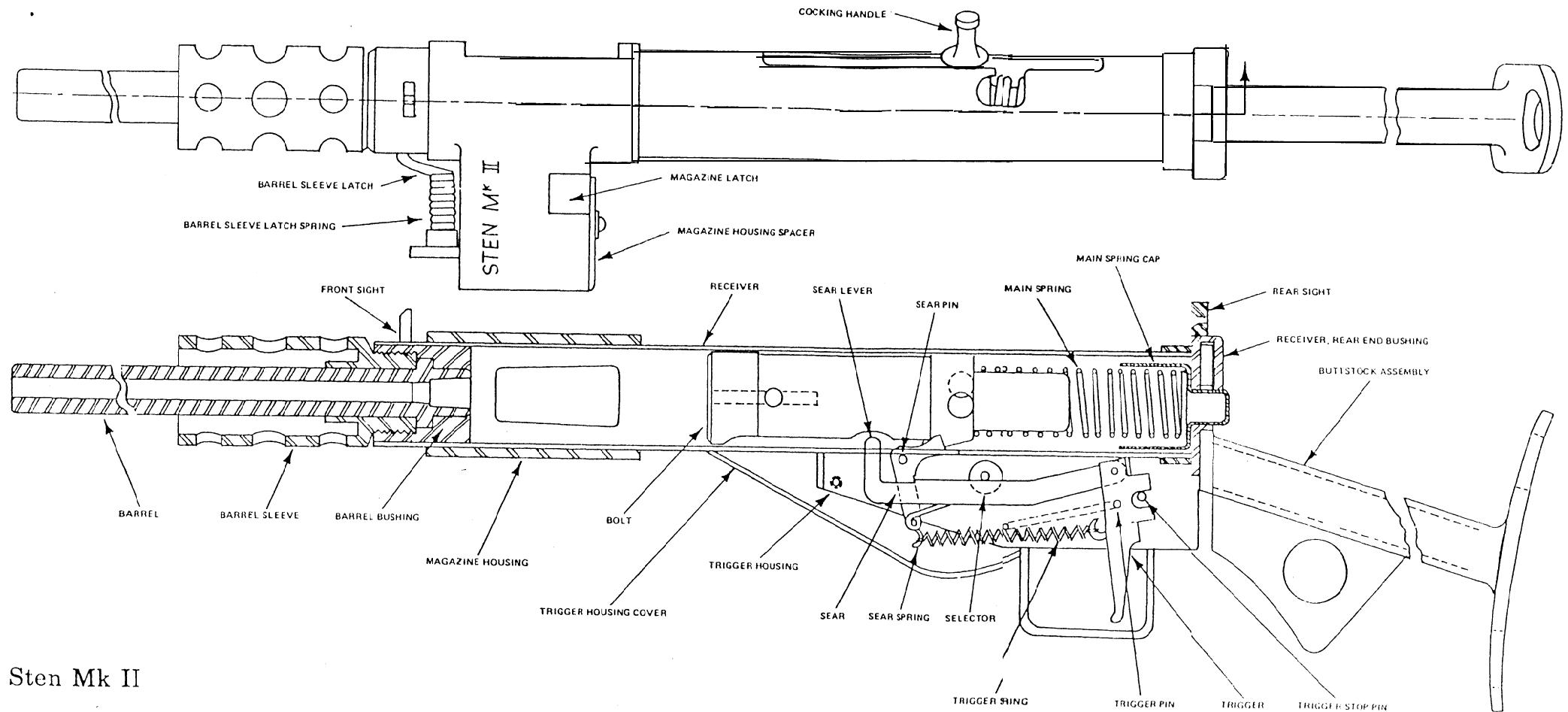
Magazine spring
Material: Music wire 1.5mm dia.



Magazine bottom retainer
Material : 1mm mild steel



Magazine bottom plate
Material: 1mm mild steel



Sten Mk II